

ASAP

Dart Aerospace Ltd.

Date: Friday, 12/7/2007 10:20:38 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 36181		
Estimate Number	: 13090		
P.O. Number	: N/A	Part Number	: D35045
This Issue	: 12/7/2007 S.O. No. : N/A	Drawing Number	: D3504 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>JA 07.12.07</u>	Due Date	: 12/14/2007
Checked & Approved By	: <u>JA 07.12.07</u>	Qty:	50
Comment	: Est Rev A Rev C dwg 07-12-06 DD	Um:	20
		Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0186 f(s)/Unit Total : 0.3717 f(s)

M6061T6R0.750

Batch: 1103155

19430 2"

20 07/12/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA712 & DWG D3504,

FOLIO REV: CDWG REV: C

2-DEBURR AS REQUIRED

20 07/12/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/12/11

(50)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.2 07/12/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LC 7/12/12

(50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-BOLT SPACER

Job Number: 36181

Part Number: D35045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

Done 12/13

Job Completion



Y 2007/12/12

Dart Aerospace Ltd

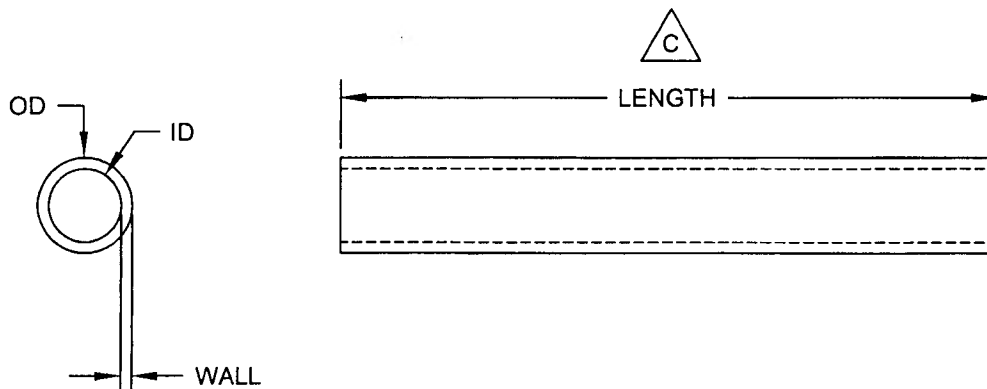
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 36181
RELEASED
07.11.16

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3504	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CROSS BOLT SPACER	NTS
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